






Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 1/4 TURN FASTNER RAIL (BLACK)
Job Number	: 34968		
Estimate Number	: 10096		
P.O. Number	: N/A	Part Number	: D103858B
This Issue	: 10/2/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D1038
First Issue	: N/A	Project Number	: N/A
Previous Run	: 34944	Drawing Revision	: B
Written By	: <u>[Signature]</u>	Material	: N/A
Checked & Approved By	: <u>[Signature]</u>	Due Date	: 11/5/2007
Comment	: Est: E 03.05.02 Reformat; Added label KJ/RF	Qty:	60
	Est Rev: F 06-08-16 Updated Packaging Procedures JLM		(50) Um: Each

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
 		
Comment: DOCUMENT CONTROL Create white labels and bag them		
2.0	D2023	Extrusion, Fastener Rail
 		
Comment: Qty.: 1.9030 f(s)/Unit Total : 95.1500 f(s) Extrusion, Fastener Rail		
3.0	BAND SAW	BAND SAW
 		
Comment: BAND SAW Cut extrusion D2023 to length 21.81" (+0.06/-0.00)		
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio and Dwg D1038-58		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
6.0	QC8	SECOND CHECK
 		
Comment: SECOND CHECK		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 1:45:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 34968

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

Bo 7/12/14 (60) counted

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 2/12/14 (x60)

9.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 5290
Black Anodize as per Dwg D1038

CL 07/12/14 (60)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage

CL 8/1/04 (60)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

5 08/01/07 (x60)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389
Batch: M104298

2-Grind wire flush and deburr

3-Clean

(PTO) X59

M 08/01/08

13.0

QC5

INSPECT WORK TO CURRENT STEP




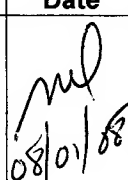

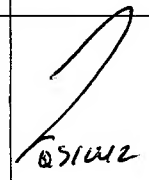
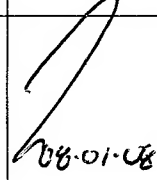
Comment: INSPECT WORK TO CURRENT STEP

5 08/01/08 (x59)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-01-08	12.0	1 part found to be unsupplied, and does not fit into the jig.	 QSI/12	Scraped destroyed, no replace. #	 08/01/08	 08-01-08	 QSI/12	 08-01-08

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 1:45:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 34968

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: 3 FG 14

AS 08/01/09

(59)

(60)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/01/11

Job Completion



W 08-01-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

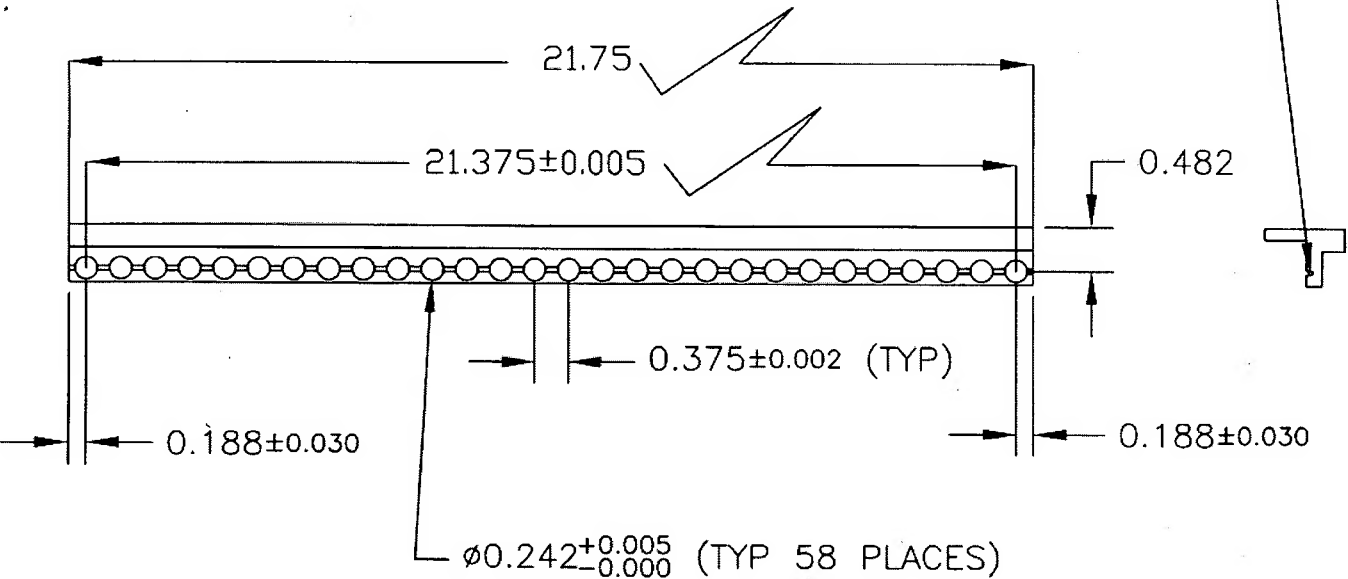
DESIGN	DRAWN BY	DRAWING NO.	REV. B
04	04	D1038	
CHECKED	APPROVED		SHEET 1 OF 1
04	04		

DATE	TITLE	SCALE
05.02.02	1/4 TURN FASTENER RAIL	NTS

RELEASED

05.03.31

	91.05.05	NEW ISSUE
A	04.05.14	UPDATE TOLERANCE
B	05.02.02	REDRAWN, UPDATE NOTES

STAKE $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)**D1038-58 1/4 TURN FASTENER RAIL**

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO 34968

TNM**ANODISATION et PEINTURE TNM INC.****C. OF C**

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

61066

21-Dec-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE**CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE:****00005290**

5222



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	50	50	D1C3858B	B34944	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	60	60	D1C3859B	B34968	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	15	15	D32993	B35139	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
4	13	13	D32991	B35138	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

